WHAT IS CLAIMED IS:

1. A method for the production of pistons having depression edge armoring for internal combustion engines, comprising the steps of:

setting a first piston blank onto a projection of an armoring ring, in a region of a depression edge of the piston blank;

connecting the armoring ring with the first piston blank in the region of the depression edge by friction-welding;

setting a second piston blank onto the armoring ring in such a manner that the two piston blanks do not touch;

connecting the second piston blank with the armoring ring in the region of the depression edge, by friction-welding to form a piston;

cutting the armoring ring between the piston blanks; and

shaping the piston by a cutting work method.

2. A method for the production of pistons according to claim 1, wherein the armoring ring has two faces and is set onto the depression edge region of one of the

piston blanks with one of its faces, in each instance, and exclusively connected to the piston blank with said face by friction welding.

3. A method for the production of pistons according to claim 1, wherein the depression edge region of the forged piston blanks is provided with a conical incline that increases radially to the outside, relative to a piston diameter.

4. A method for the production of pistons according to claim 3, wherein the faces of the armoring ring are structured conically, with mirror-image symmetry relative to one another, and have the same incline as the depression edge region of the piston blanks.

5. A method for the production of pistons having depression edge armoring according to claim 4, wherein the incline comprises an angle range from 25 to 50 degrees.

6. A method for the production of pistons having depression edge armoring according to claim 2, wherein the

piston head produced by the step of shaping is formed at least partially by one of the faces of the armoring ring.